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DART AEROSPACE LTD	Work Order:	19213
Description: Chafing Shield	Part Number:	D3189-1
Dwg: D3189 Rev. A	Qty:	74.8 ✓
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	03.05.22	74.8
2	GA	Cut blank: 11.25" x 4.13" Material: AISI 304/316 SS 0.020" thick sheet (M304S25GA) Batch: <u>M2070</u>	RB	03.05.21	8
3	GA	Grind corner as per Dwg D3189	RB	03.05.21	8
4	GA	Deburr	RB	03.05.21	8
5	GA	Roll as per Dwg D3189	RB	03.05.21	8
6	QC5	Inspect work to Step 4	MR	03.05.28	8
7	LG	Identify and Stock	RB	03.05.28	8
8	AC	Cost / part : 92	SUR	03.05.29	8
9	DC	Close W/O : 92 Inspect Level 21	A	03.05.29	-

Rev	Date	Change	Revised By	Approved
A	03.05.15	New issue	KJ/RF #	#

RELEASED

03.05.20 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

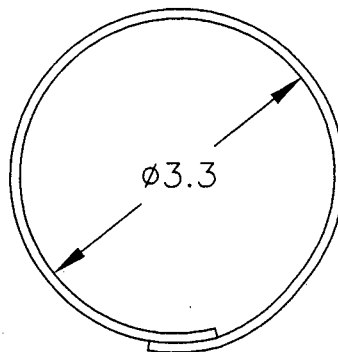
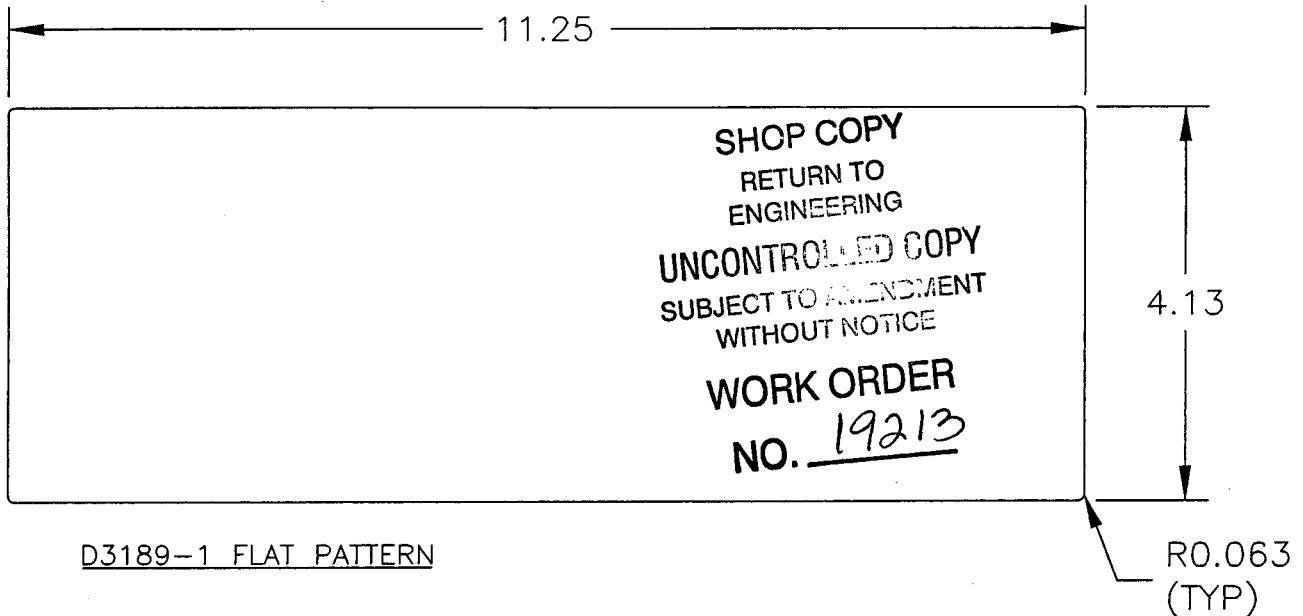
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3189	REV. A SHEET 1 OF 1
DATE 03.05.08		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	

RELEASED
03.05.08 #



D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 22, 2003
01:38 pm

Work Order No : 0019213
Project Name : D3189-1
Project For : WK23
Work Order Type : Main
Main WO Number :
House Part Number : D3189-1
Description : Chafing Shield
Manufactured : Yes
Amount Req'd : 14.8
Amount Done : 0
Start Date : 05-22-03
Est Finish Date : 06-04-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00